Date:

Friday, 01/08/2008 10:42:30 AM

User:

Julie Lecocq

**Process Sheet** 

Customer

Prsht Rev.

: CU-DAR001 Dart Helicopters Services

**Estimate Number** 

Job Number

: 40893B : 10841 -

P.O. Number

This Issue

: 01/08/2008

: NC

First Issue

Previous Run

: //

: SMALL /MED FAB

: 40486B

Type

S.O. No. :

**Drawing Revision** Material

**Due Date** 

**Drawing Name** 

**Part Number** 

**Drawing Number** 

Project Namber

: 10/08/2008

: LUG

: D22493

: N/A

: E

: D2249 REV. E

Qty:

10 Um:

Each

Checked & Approved By

Comment

Written By

D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now On Waterjet 07-03-08 JLM

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:



Comment: Qty.:

Total: 0.1470 sf(s)/Unit

1.4700 sf(s)

304/316 .063 Sheet

Batch:

2.0

WATER JET

FLOW WATER JET

304/316 Sheet .063

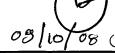


Comment: FLOW WATER JET

1-Cut as per Dwg D2249 Dwg Rev:

B8-8-8

Prog Rev:



3.0

QC2

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE

B8-8-8

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D2249



12

Page 1

## **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANG	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		•									
Part No	····	PAR #· Fault Category:	NCP: Vas	No DO	۸.	Date:	J				

					QA: N/0	C Closed:	_ Date: _	<u>.</u>
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCR)			
		Description of NC		Corrective Action Section E	}	Verification		A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
					; ;			
,				•				

NOTE: Date & initial all entries

	ay, 01/08/2008 10:42:30 AM Lecocq	Draces Sheet
	CU-DAR001 Dart Helicopters Services	Process Sheet  Drawing Name: LUG
Job Number:	40893B	Part Number: D22493
Job Number:		Fatt Number, 022400
Seq. #:	Machine Or Operation:	Description :
6.0	QC5	INSPECT WORK TO CURRENT STEP
	nt: INSPECT WORK TO CURRENT STEP	S 07 65 65 (x/2)
7.0	PACKAGING 1	PACKAGING RESOURCE #1
Comme	Identify and Stock Location:	28 09/05/05 60E
8.0	QC21	FINAL INSPECTION/W/O RELEASE
Comme	nt: FINAL INSPECTION/W/O RELEASE	
Job Completion		mf 09-05-05
•		
	·	,

## **Dart Aerospace Ltd**

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date: _	

QA: N/C Closed: \_\_\_\_ Date: \_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B			Verification	Annroyal	Approval	
DATE	STEP Section A		Section A Initial Action Description Sign & Date		Section C	Approval Chief Eng	Approval QC Inspector		
			·						

NOTE: Date & initial all entries

DART AEROS	SPACE LTD			1	Work Order:	40893B
escription:	LyG				Part Number:	02249-3
nspection Dwg	:D3349-3 Rev:	E				Page 1 of 1
	FIRST	ARTICLE IN	ISPECTION	ON CHE	CKLIST	
	X	7		Proto		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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.375	4/010	1318	*			
.400	4 010	1402	×			
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3,690	-010	3,693	×			
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Meası	red by:	B	Audited by:	2 1	Prototype Approva	: 1	//
	Date:	8-8-8	Date:	081008	Date	:	19
Rev	Date	Change			Revise	d by	Approved
Α		New Issue			KJ/JLN	]	

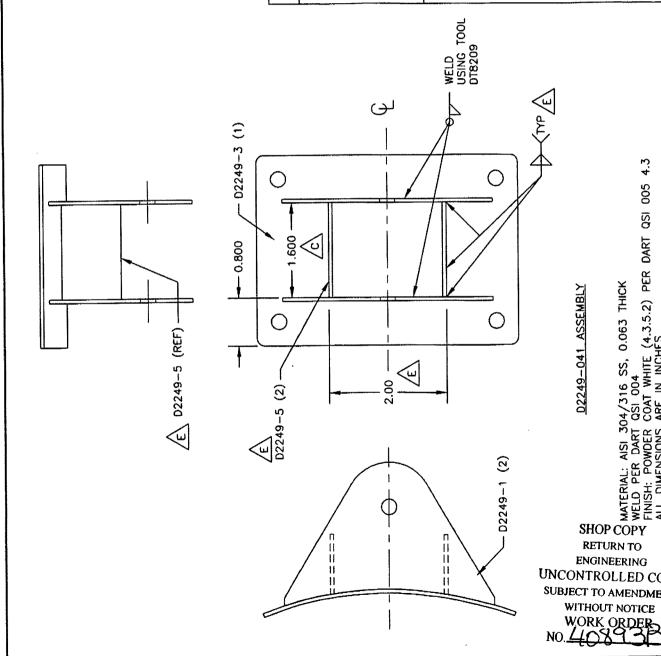


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DATE		TITLE	SCALE
99.09.20		FITTING	NTS

## RELEASED 199.10.12 KE

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I DAIL		I HILL	00/100
 99.09.20		FITTING	NTS
Α	94.06.20	NEW ISSUE	
В	95.11.30	DIMENSION CHANGE	
С	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	



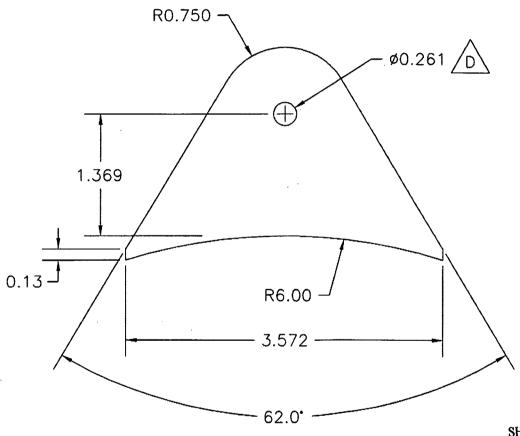
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED : AISI 304/316 SS, 0.063 THICK SHOD CODA MATERIAL: RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT





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DATE		TITLE	SCALE
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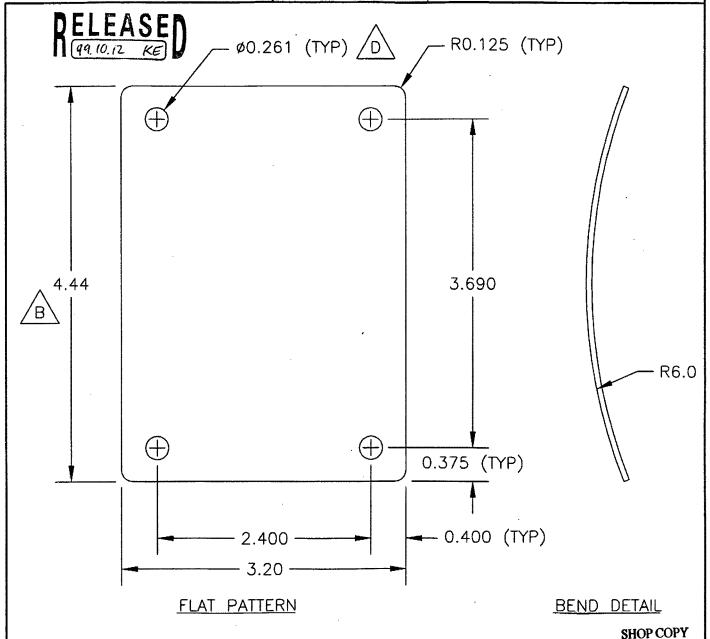
D2249-1 LUG

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RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

MATERIAL: AISI 304/316 SS 0.063 THICK ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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ME	#	D2249	SHEET 3 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	1:1



D2249-3 BASE PLATE

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ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WORK ORDER

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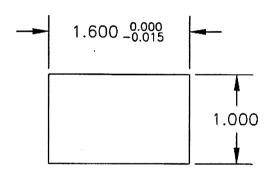
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D2249-5 GUSSET

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